WHAT IS CLAIMED IS:

1. A DWI can for packaging light colored fruits and vegetables, comprising:

a bottom;

a sidewall integral with said bottom, said sidewall comprising a steel substrate, a first coating comprising tin on an outer surface thereof and a second coating comprising tin on an inner surface thereof, said second coating having a mass per unit area that is at least 0.15 pounds of tin per base box, said sidewall further comprising no additional protective coating on said second coating; and

a top end secured to said sidewall,

wherein said sidewall is fabricated by a drawn wall ironing process from a tin coated steel substrate.

2. A DWI can according to claim 1, wherein said second coating has a mass per unit area that is at least 0.20 pounds of tin per base box.

3. A DWI can according to claim 2, wherein said second coating has a mass per unit area that is at least 0.25 pounds of tin per base box.

4. A DWI can according to claim 1, wherein said second coating is thicker than said first coating.

5. A DWI can according to claim 1, wherein said second coating is unbreached.

6. A method of making packaging for light colored fruits comprising steps of: √

(a) providing a base material having a steel substrate, a first layer of tin material on a first side of said substrate and a second layer of tin material when a second side of said substrate, with no additional protective coating on said second layer;

(b) using the drawn wall ironing process to form said base material into a can body for a DWI can having a bottom surface and a sidewall comprising an exterior surface corresponding to said second layer that has a first coating comprising tin and an interior surface corresponding to said first layer having a second coating also comprising tin that is thicker than said first exterior coating;

(c) inserting foodstuffs into the can body so that said foodstuffs are exposed to said tin surface; and

(d) applying a top end to the can body.

7. A method according to claim 6, wherein said second coating has a mass per unit area that is at least 0.15 pounds of tin per base box.

8. A method according to claim 7, wherein said second coating has a mass per unit area that is at least 0.20 pounds of tin per base box.

9. A method according to claim 8, wherein said second coating has a mass per unit area that is at least 0.25 pounds of tin per base box.

10. A method according to claim 6, wherein said first layer has a mass per unit area that is at least 0.50 pounds of tin per base box.

11. A method according to claim 6, wherein said first layer has a mass per unit area that is at least 0.60 pounds of tin per base box.

12. A method according to claim 6, wherein said first layer has a mass per unit area that is at least 0.675 pounds of tin per base box.

13. A method according to claim 6, wherein said second layer has a mass per unit area that is at least 0.10 pounds of tin per base box.

11. A method according to claim 6, wherein said second layer has a mass per unit area that is at least 0.125 pounds of tin per base box.

12. A method according to claim 6, wherein said second layer has a mass per unit area that is at least 0.15 pounds of tin per base box.

14. A method according to claim 1, wherein said first layer has a mass per unit area that is at least 100 pounds of tin per base box.

15. A method according to claim 14, wherein said first layer has a mass per unit area that is at least 120 pounds of tin per base box.

16. A method according to claim 15 wherein said first layer has a mass per unit area that is at least 135 pounds of tin per base box.

17. A method according to claim 11, wherein said second layer has a mass per unit area that is at least 20 pounds of tin per base box.

18. A method according to claim 17, wherein said second has a mass per unit area that is at least 25 pounds of tin per base box.

19. A method according to claim 18, wherein said second layer has a mass per unit area that is at least 30 pounds of tin per base box.

20. A method according to claim 6, wherein said first layer has a greater mass per unit area than said second layer.

21. A method according to claim 6, wherein said first layer is thicker than said second layer.